

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020513**Date Inspected:** 09-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Sha Zi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair of Weld joint 090 as per CWR no. B-CWR-2646, Located on Lift 14E longitudinal diaphragm to Floor beam. Welder is identified as 066422. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-345 –SMAW -2G (2F)-FCM-Repair.

Repair of Weld joint 010 as per CWR no. B-CWR-2775, Located on Lift 14E longitudinal diaphragm to Floor beam. Welder is identified as 066418. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-345 –SMAW -2G (2F)-FCM-Repair.

Repair of Weld joint 035 as per WRR no. B-WR-20210, Located on Lift 13AE, Side panel to Floor beam, SEG3007AD. Welder is identified as 216086. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-345 –SMAW -2G (2F)-FCM-Repair.

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Weld joint 055, Located on Floor beam to AP in Lift 14E, SEG3019L. Welder is identified as 068097. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

Flux Cored Arc Welding (FCAW)

Weld joint 230, Located on Lift 14E, SEG3019AP. Welder is identified as 052696. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint 112, Located on Floor beam stiffener at Lift 13AE, SEG3009T. Welder is identified as 066163. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Bay #19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 19;

Suspender Bracket SB 106E, SB 106W, SB 108E

Bike path BK004A-014

Bike path BK005A-002

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay #16

Weld joint 016, 017 Located on Bottom plate to stiffener, BP3095-001. Welder is identified as 068858. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer